

Date: Tuesday, 2/26/2008 8:00:59 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 37618
 Estimate Number : 12467
 P.O. Number :
 This Issue : 2/26/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 36180
 Part Number : D35121
 Drawing Number : D3512 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 3/31/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : 808 02 26
 Comment : Est Rev:A New Issue 06-06-20 JLM
 Est Rev:B Now SS as per Rev B 06-12-15 JLM
 Est Rev:C Rev C dwg 07-12-06 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.2741 sf(s)/Unit Total: 3.2886 sf(s)
 304 SS .063" THK (16 GA)
 (M304S16GA)
 Batch: 106860 IB 8-3-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3512
 Dwg Rev: C IB 8-3-4
 Prog Rev: C

2-Deburr if necessary IB 8-3-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Deburr if necessary
 Form as per dwg D3512 using DT8179

808/03/12 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:00:59 AM
User: Kim Johnston

Process Sheet

30/11/08

17/04/2008

S.049 15.29

#1 322.5 F

#2 37618 F

#3 F

D35121 F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 37618

Part Number: D35121

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/12 (12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004

Qty Description Batch

A/R 2059b Hardcoat Rod M 107051

08-04

SP

(12)

8.0

QC10

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-04-16

(11)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

BR 08-04-17

(11)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FZ 08/04/18 (11)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST497

08/04/18 (11)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/18

Job Completion

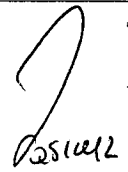
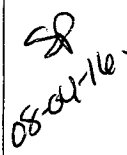
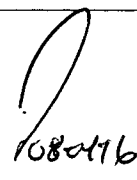
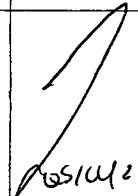



MF 08-04-17

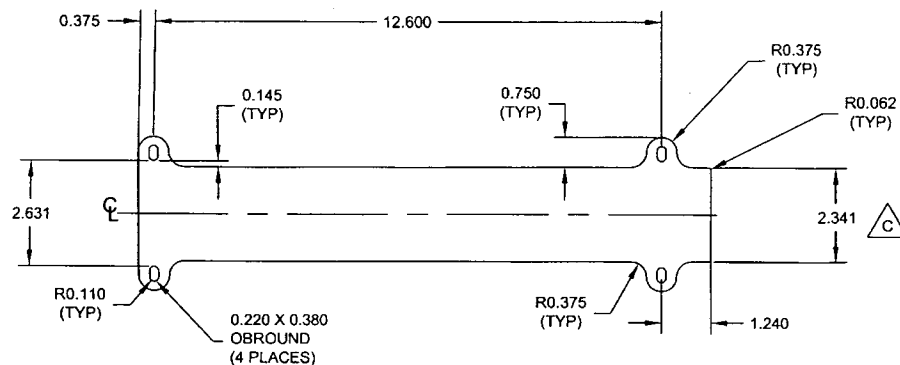
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

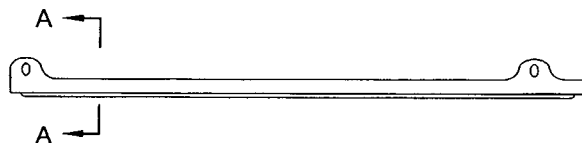
Part No: D3512-1 PAR #: Fault Category: Prod / MB. ASS. NCR NCR: Yes No DQA: D Date: 08/04/08
435-751 QA: N/C Closed: Date:

NCR: 37618		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-04-06	8.0	1 part scrap, Employee wandered off to one side while welding, leaving the center on the wear pad more exposed. Lost L.C. didn't follow the line scribed / marked out while welding.		Ensure to clearly identify the weld line, even during weldings. Scrap and no replace				

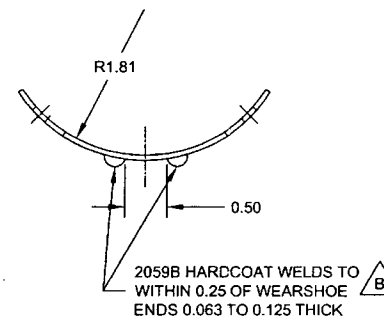
NOTE: Date & initial all entries



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3

RELEASED
67.11.16



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
TO ADJ
WITHOUT N
OFFICE
WORK ORDER
37618

C	ENLARGE OBOURND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		
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